












ASAP

Date: Thursday, 25/09/2008 8:45:08 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 42279	
Estimate Number : 12811	
P.O. Number :	Part Number : D35921
This Issue : 25/09/2008 S.O. No. :	Drawing Number : D3592 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 41083	Material :
Written By : <u>W</u>	Due Date : 02/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 07-03.26 ec	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6S125 6061-T6 .125 Sheet
	 
Comment: Qty.: 0.1460 sf(s)/Unit Total: 2.9190 sf(s) 6061-T6 .125 Sheet Batch: <u>109058</u> <u>B 8-9-05</u> ***Grain must be Along 4.63*****	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D3592 *****ENSURE GRAIN IS AT 45 DEG AS PER DEO d3592-b-1***** Dwg Rev: <u>B</u> <u>B 8-9-05</u> <u>(21)</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B 8-9-05</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-9-05</u>	
4.0	QC8 SECOND CHECK
	 
Comment: SECOND CHECK <u>S 08/09/25</u> <u>(22)</u> <u>counted</u>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3592 using DT8949 <u>S 08/09/29</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 25/09/2008 8:45:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42279

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/09/29 (21)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Pat W

8/9/29

(21x)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 J

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

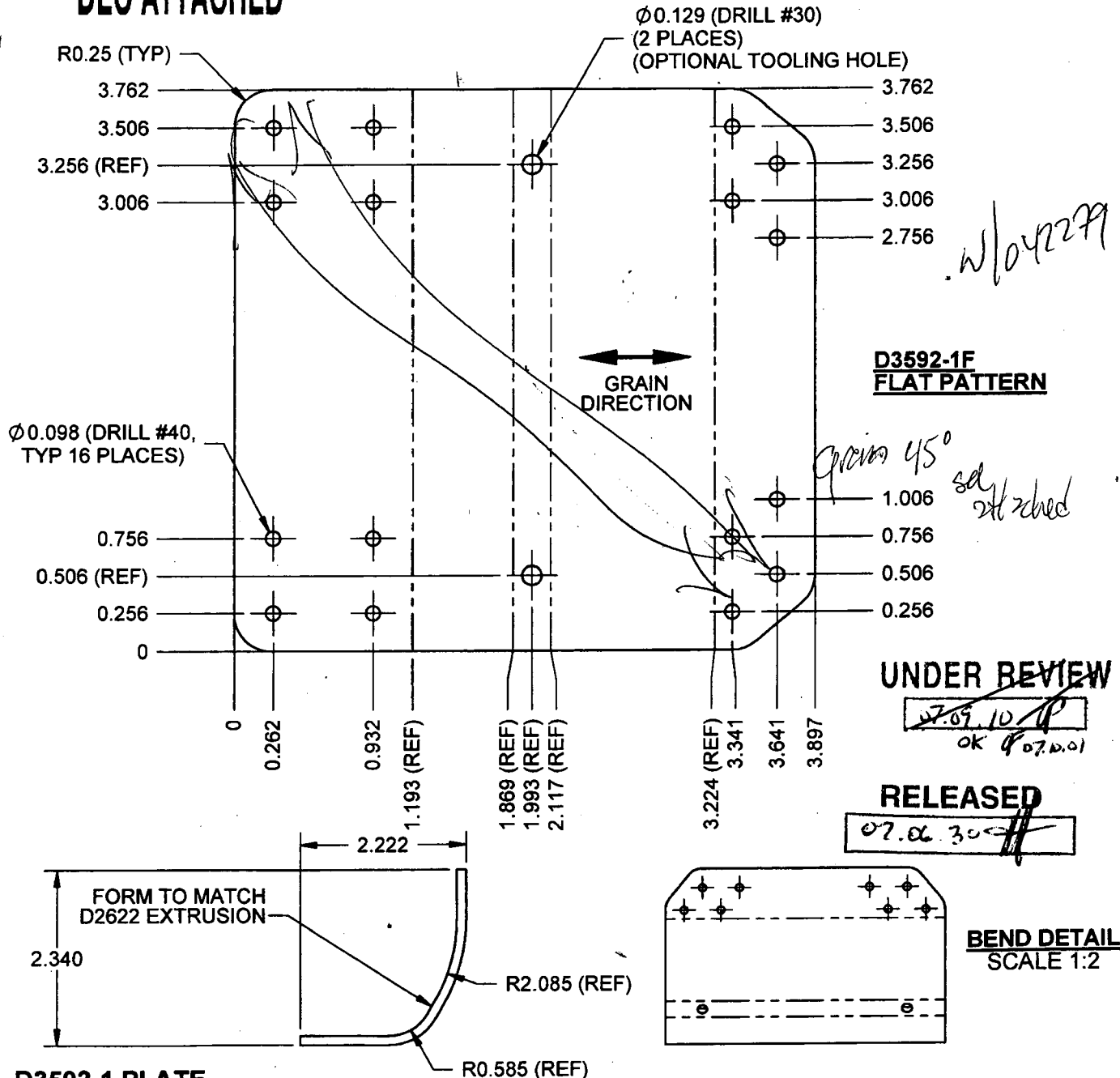
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>DL</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3592</b>	REV. B SHEET 1 OF 1
DATE <b>07.05.31</b>	TITLE <b>PLATE</b> SCALE 1:1		
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**DEO ATTACHED****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

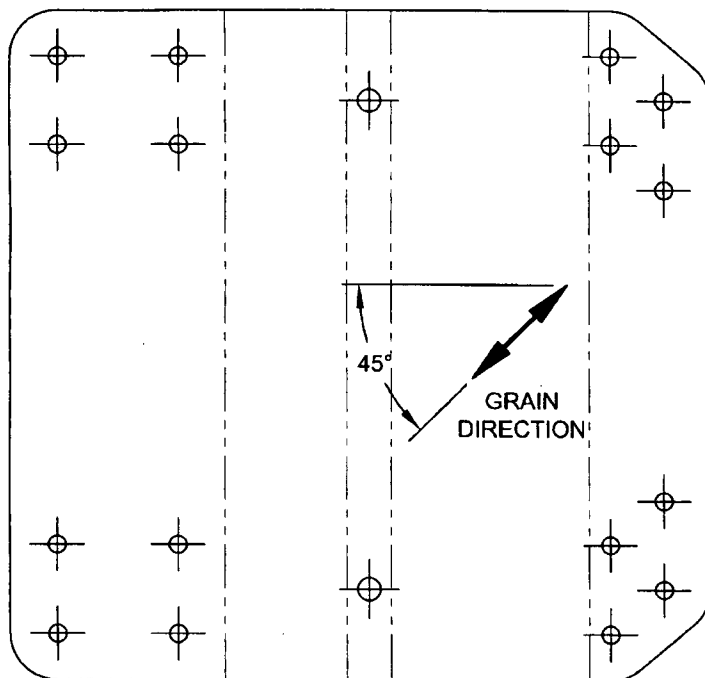
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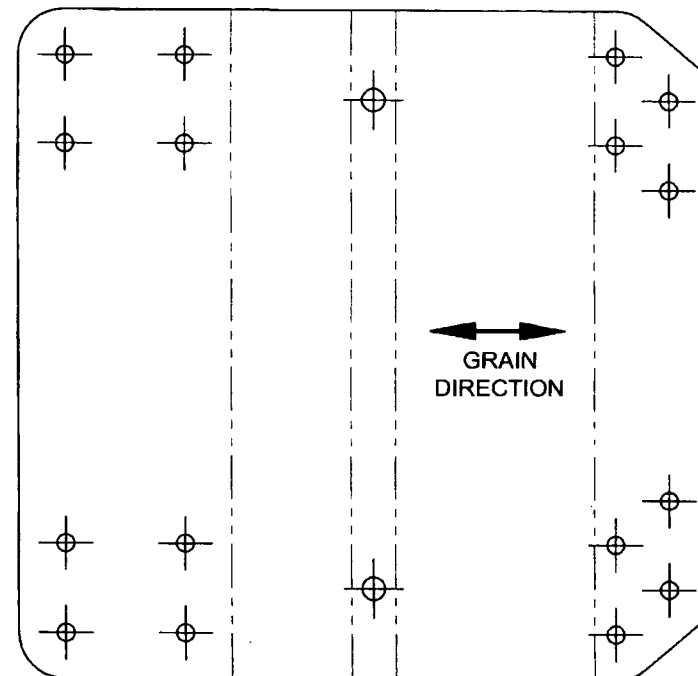
DRAWING NO. D3592	TITLE PLATE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3592-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.09.11	DATE 08.09.11	DATE 08/09/11	DATE 08/09/11		DATE 08/09/11		

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

IS:



WAS:



*No 42279*

ALL OTHER INFORMATION REMAINS UNCHANGED

**RELEASED**  
*08.09.17*

## L Lacelle

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**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** September 25, 2008 8:03 AM  
**To:** 'L Lacelle'  
**Cc:** 'Alan Stocker'; 'Bill Beckett'; 'Jason Murdoch'  
**Subject:** RE: Darts 412-630-033/034 steps  
**Attachments:** d3592.JPG

It's not under review because it doesn't need to be. There is an EO attached that corrects the grain direction.

Give 'er.....

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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** September 25, 2008 7:52 AM  
**To:** 'Mike Petsche (E-mail)'  
**Cc:** 'Alan Stocker'; 'Bill Beckett'; 'Jason Murdoch'  
**Subject:** FW: Darts 412-630-033/034 steps  
**Importance:** High

I just heard that the d3592-1 plates are on hold, however the drwg is not under review...we need a solution asap,  
I only have 1 set of folding steps left in stock...  
LL

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**From:** Peggy McDonald [mailto:peggy@darths.com]  
**Sent:** September 24, 2008 1:09 PM  
**To:** 'Bill Beckett'  
**Cc:** 'L Lacelle'; 'David Shepherd'  
**Subject:** Darts 412-630-033/034 steps  
**Importance:** High

Good Morning,  
Just a heads-up

I was told this morning that AAI will no longer offer the 412 steps.  
I was asked to ensure we have stock on the shelf as our steps are now frequently quoted.

Peggy

Warm Regards,  
**DART HELICOPTER SERVICES**  
Peggy McDonald  
Director of World Wide Sales

Tel: 613.632.3336  
Toll Free: 1.800.556.4166  
Fax: 613.632.4443  
Cell: 613.676.1710

25/09/2008

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42279
<b>Description:</b> BRACKET		<b>Part Number:</b> D3592-1
<b>Inspection Dwg:</b> D3592-1, Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.102	X			
Ø .129	+ .005 - .001	.132	X			
3.762	+/- .010	3.771	X			
3.897	+/- .010	3.899	X			
3.506	+/- .010	3.506	X			
3.256	+/- .010	3.256	X			
3.006	+/- .010	3.008	X			
2.756	+/- .010	2.756	X			
1.006	+/- .010	1.006	X			
.756	+/- .010	.758	X			
.506	+/- .010	.506	X			
.256	+/- .010	.257	X			
.262	+/- .010	.264	X			
.932	+/- .010	.933	X			
1.993	+/- .010	1.994	X			
3.341	+/- .010	3.343	X			
3.641	+/- .010	3.642	X			

<b>Measured by:</b>	B
<b>Date:</b>	8-9-25

<b>Audited by:</b>	S
<b>Date:</b>	08/09/25

<b>Prototype Approval:</b>	1/
<b>Date:</b>	7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	